

Work Order ID 63248



Page 1

Tuesday, October 26, 2010 10:37:31 AM

Item ID: D3508-13

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 10/26/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: JMFDate: 10-10-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3508 | Rev C |

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

364 . 040

Memo

0.00

B10-10-271-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(14)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-10-27

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

S 010127

(14)

QC

Quality Control

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes | No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start



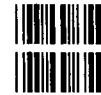
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261as per Dwg D3508

14

SB 10/10/27

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 10/10/27

14

10/10/27

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld hardcoat as per dwg D3508 QSI004 Hardcoat 2059b Batch: 115879

14 10/10/28

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

S 1010127

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 1010129

(14)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112 588

0.00

Memo

START TIME:

2:45

OVEN TEMPERATURE:

3:20

FINISH TIME: 3:15

K1 B6/10-11-3.

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC3- Inspect Part Finish

0.00

=> M. 10/11/03

14 φ

QC

Memo

0.00

Quality Control

200



Identify as per dwg & Stock Location: EPK

0.00

14 BK 10-11-3

Packaging

Memo

0.00

Packaging

210



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/04 JJ

MF

10-11-3

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:37:31 AM

Page 1

Work Order ID: 63248



Parent Item: D3508-13



Parent Item Name: Wearplate

Start Date: 10/26/2010

Required Date: 11/2/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|-----------------|--------|
| M304S20GA | | Purchased | No | | | 100 | sf | 176.7000 | 0.172 | 1.086316 | | 25 B10-10-27 | |

304/316 .040 Sheet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 172.7 | |
| | 12.7 | |
| | 160 | |
| MAT20 | 4 | |
| | 1.398 | |
| | 2.602 | |

(14)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 63248 |
| Description: Wearplate | Part Number: | D3508-13 |
| Inspection Dwg: D3508 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | PB | Audited by: | S | Prototype Approval: | N/A |
| Date: | 10-10-27 | Date: | 10/10/27 | Date: | N/A |

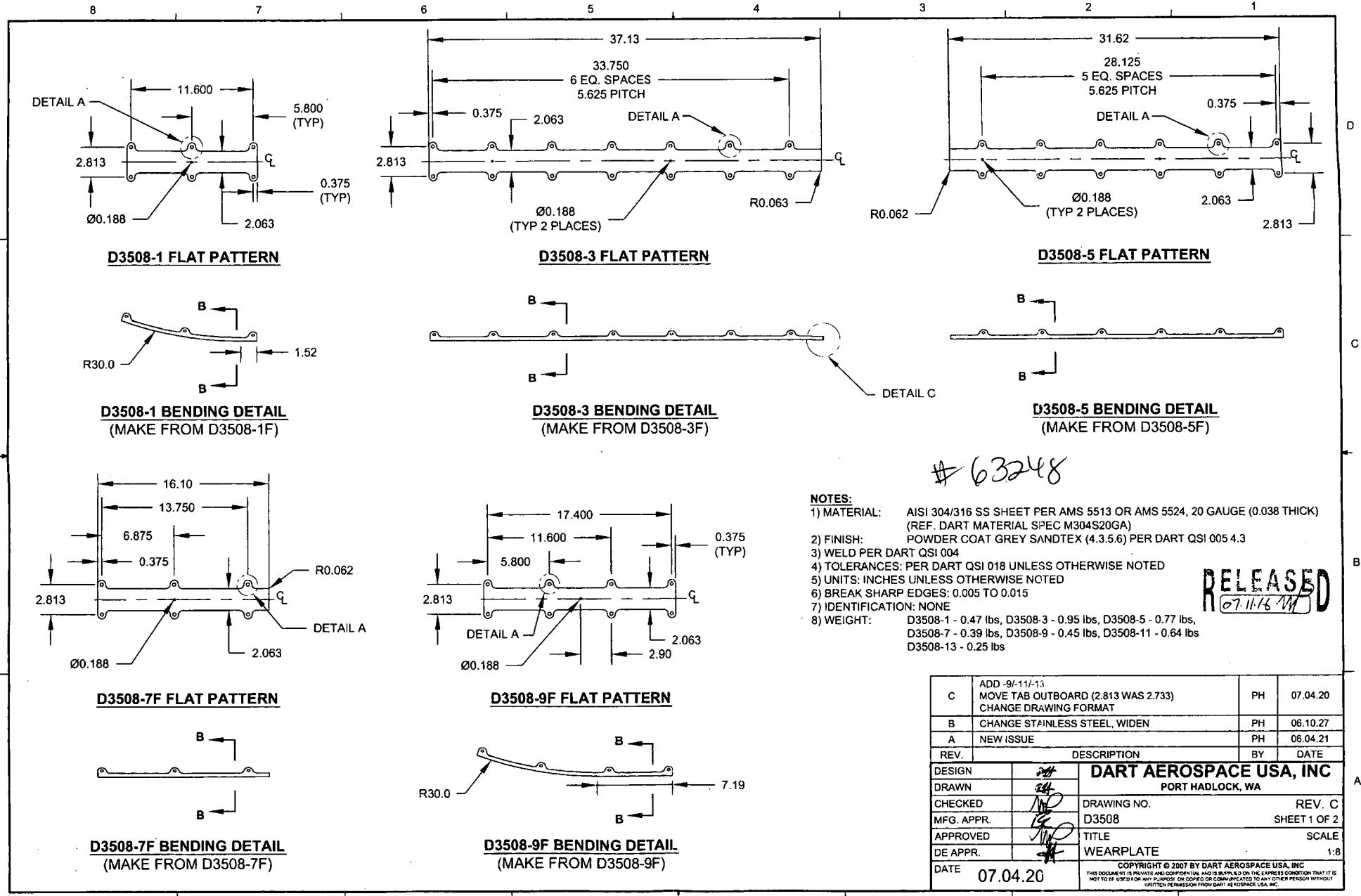
| Rev | Date | Change | Revised by, | Approved |
|-----|----------|-----------|-------------|---------------------------------------------------------------------------------------|
| A | 08.01.23 | New Issue | KJ/EC/DD |  |

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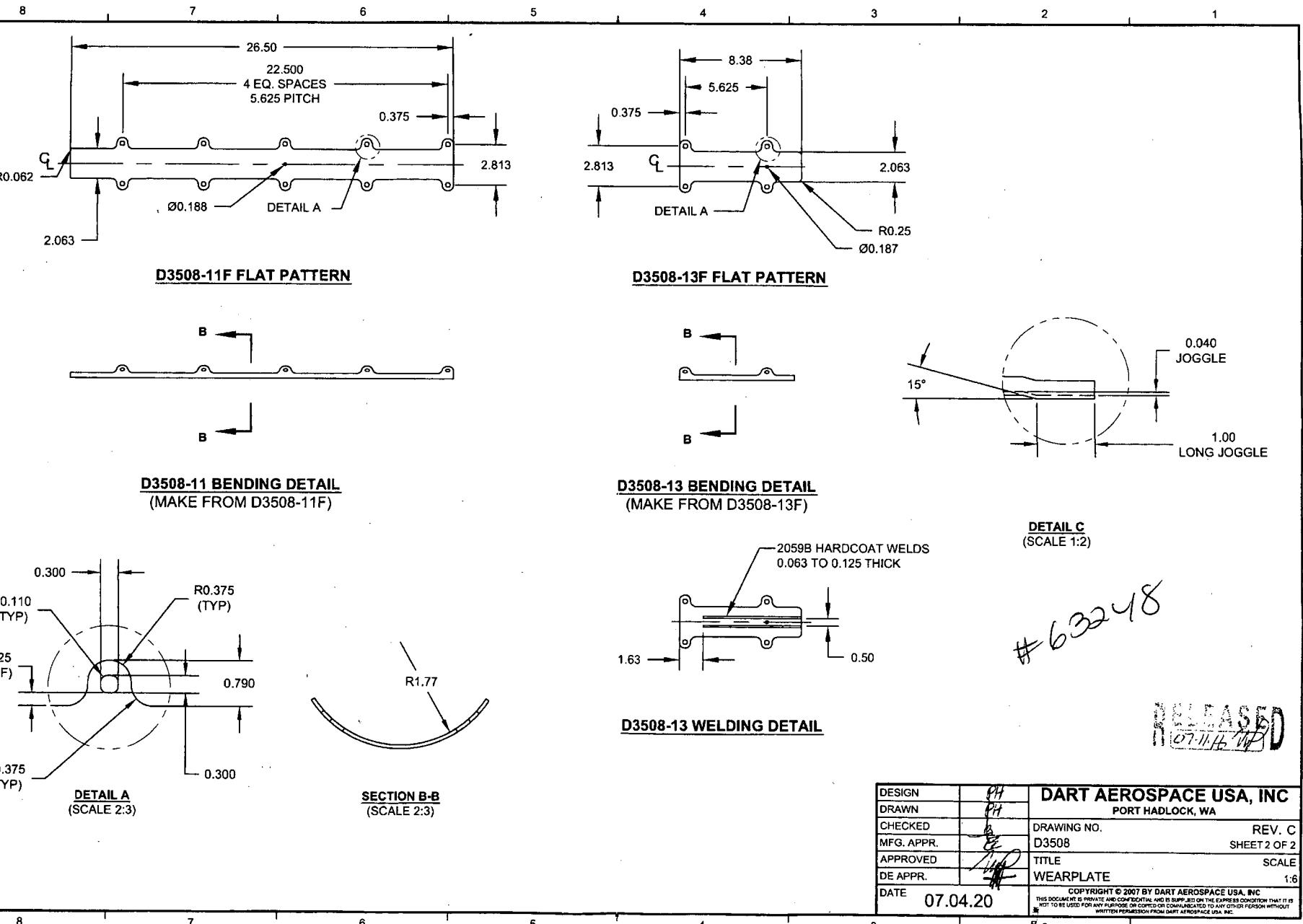
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